

~~54833~~ De rev 55701

Work Order ID 53899

November 23, 2009 11:27:01 AM



Page 1

Item ID:	D3798-5	Accept		Setup	Start	
Revision ID:	B				Stop	
Item Name:	Reinforcement					
Start Date:	23/11/2009	Start Qty:	10.00		Cust Item ID:	
Required Date:	27/11/2009	Req'd Qty:	10.00		Customer:	

Reference:

Approvals:	Process Plan:	<u>BA</u>	Date:	<u>09-11-23</u>	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3798	B								
100	FLOW WATER JET	0.00							
	Waterjet								
FLOW CNC Waterjet	Memo	0.00							
	1-Cut as per Dwg D3798								
	Dwg Rev: <u>B</u>								
	Prog Rev: <u>B</u>								
	2-Deburr if necessary								
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
	QC								
Quality Control	Memo	0.00							
120	QC8- Inspect parts - second check	0.00							
	QC								
Quality Control	Memo	0.00							

B 9-12-2

(17)

B 9-12-2

(17)

27 804/12/03

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Revision ID:	B				Stop	
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Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:
	QC:	Date:	SPC (Y/N):	Date:

Run	Start	
	Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 HandFinish Hand Finishing	Chemical Conversion Coat per QS1005 4.1 Memo	0.00 0.00	MD 09/12/03			X17			
140 QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00	M 09/12/03			X17	Ø		
150 Packaging Packaging	Identify as per dwg & Stock Location: GA Memo	0.00 0.00	SB 09/12/04			(17)			

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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NOTE: Date & initial all entries

November 23, 2009 11:27:01 AM



Accept

**Setup Start**

B

Stop



Reinforcement

**Cust Item ID:**

Customer:

Reference:

Run Start

**Approvals:**

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Operation Description

Set Up/ Run Hours

**Draw
Number**

Draw
Rev.

**Plan
Code**

Accept Qty

Reject
QtyReject
Number

**Insp.
Stamp**

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/01/28

MF 09-12-07

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Page 1

Work Order ID: 53899



Parent Item: D3798-5



Parent Item Name: Reinforcement


Start Date: 23/11/2009

Required Date: 27/11/2009

Comments:

Start Qty: 10.00

Required Qty: 10.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M6061T6S.050		Purchased	No			100	sf	132.5716	12.9263	22.		
<div>  <div> <div></div> <div></div> </div> </div>												
6061-T6 .050 Sheet												

B9-12-2

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
MAT	132.5715	
110791	34.5715	
113216	96	
17349	2	

97

113216

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

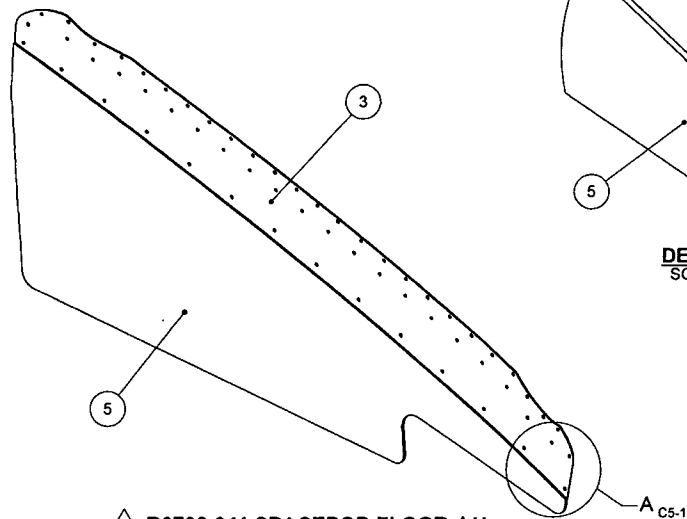
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

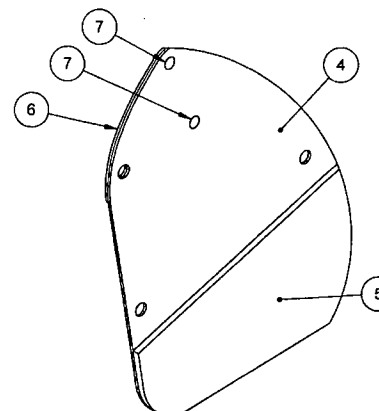
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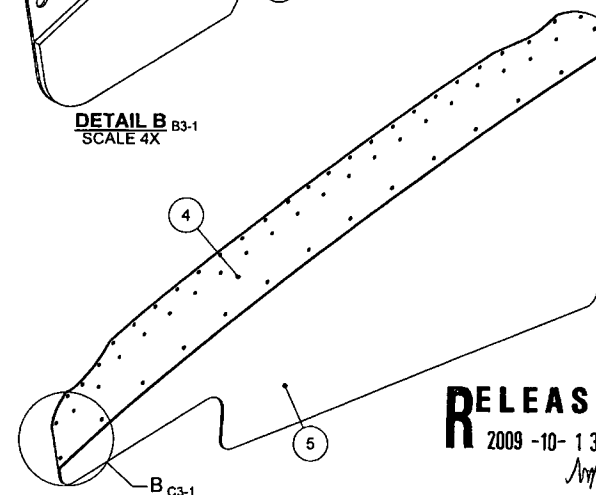
ITEM NO.	QTY. -041	QTY. -042	PART NUMBER	DESCRIPTION
1	X		D3798-041	SPACEPOD FLOOR ASSEMBLY, LH
2		X	D3798-042	SPACEPOD FLOOR ASSEMBLY, RH
3	1		D3798-1	SPACEPOD FLOOR
4		1	D3798-2	SPACEPOD FLOOR
5	1	1	D3798-3	SPACEPOD FLOOR FOAM
6	1	1	D3798-5	REINFORCEMENT
7	33	33	MS20426AD4-3	RIVET



D3798-041 SPACEPOD FLOOR, LH



**DETAIL B B3-1
SCALE 4X**



D3798-042 SPACEPOD FLOOR, RH

UNCONTROLLED
SUBJECT TO
WORK
NO. 53889
2109-11-23

RELEASED
2009-10-13

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT BLACK SANDTEX (4.3.5.7) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3798-041/-042 USING WHITE FINE POINT PERMANENT MARKER
- 7) WEIGHT: D3798-041 - 5.0 lbs
D3798-042 - 5.0 lbs

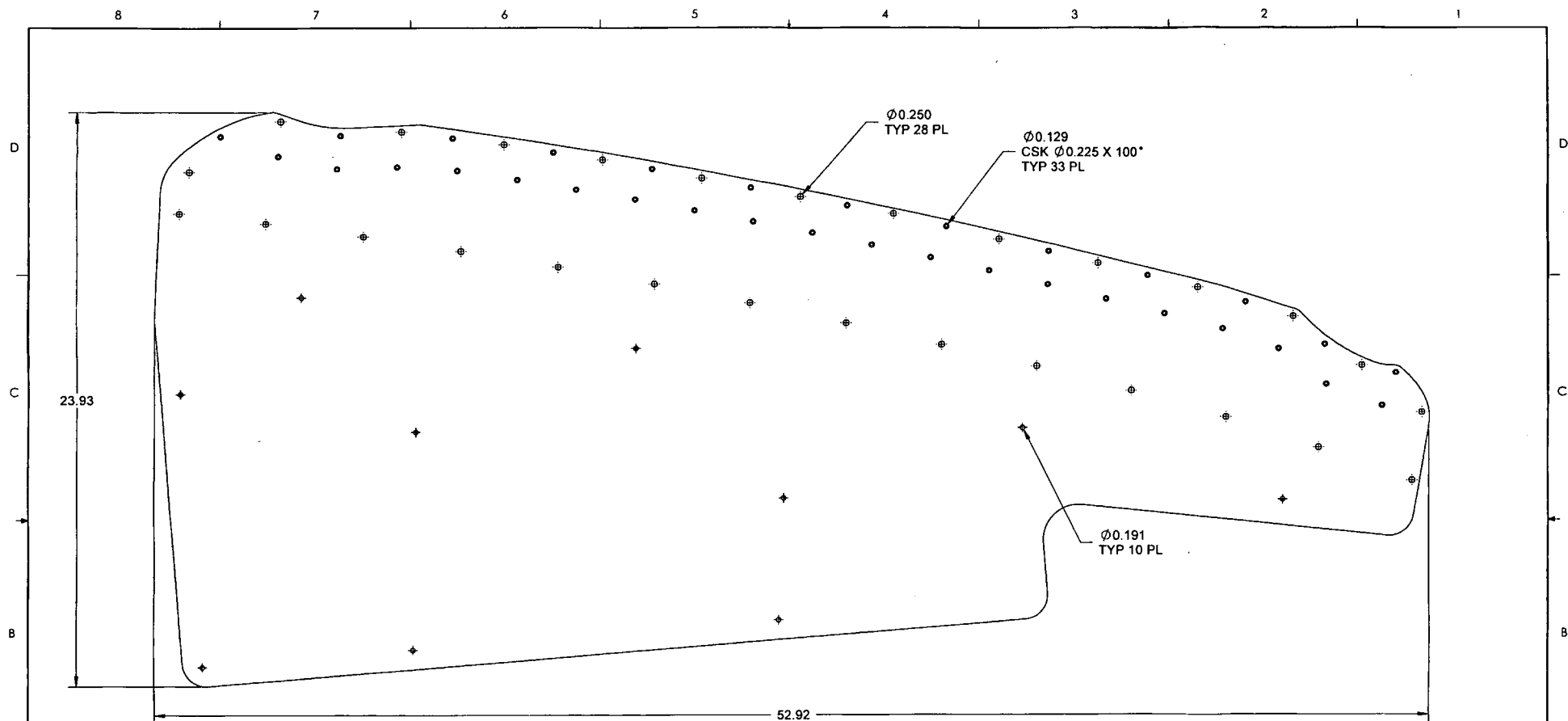
- 8) ASSEMBLY INSTRUCTIONS**
- RIVET D3798-5 REINFORCEMENT TO D3798-1/-2 SPACEPOD FLOOR USING RIVETS AS INDICATED
 - POWDER COAT PER NOTE 2
 - INSTALL D3798-3 FOAM AS INDICATED USING CONTACT CEMENT. TRIM TO FIT.

B	ADD -5 (SHEET 4); REVISE -041/-042; ADD ASSEMBLY INSTRUCTIONS (NOTE 8)	HS	09.10.08
A	NEW ISSUE	HS	08.10.20
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	09.10.08		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. REV. B
D3798
SHEET 1 OF 5
TITLE SCALE
SPACEPOD FLOOR NTS

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D3798-1 SPACEPOD FLOOR

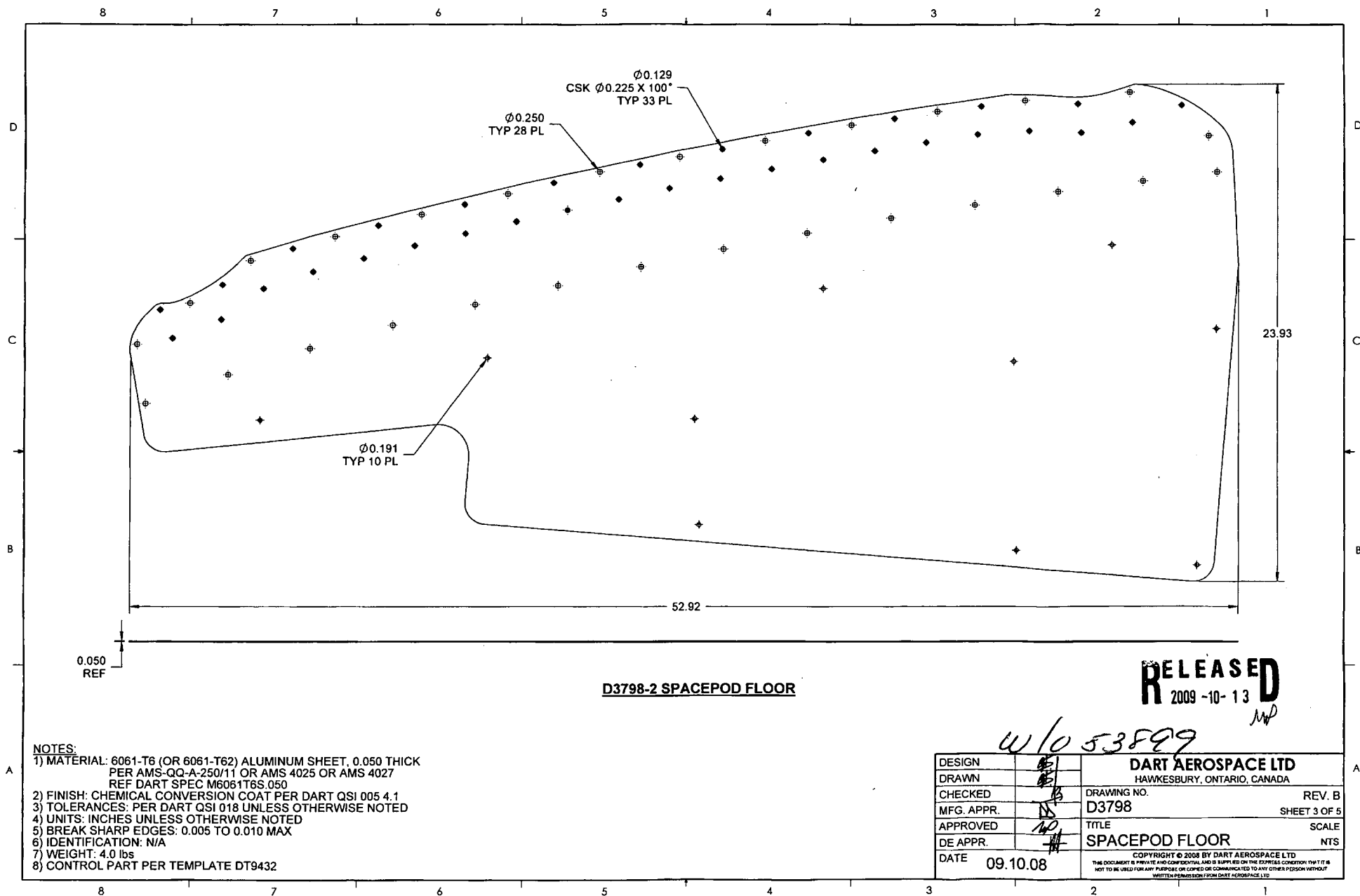
NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.050 THICK
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
REF DART SPEC M6061T6S.050
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 4.0 lbs
- 8) CONTROL PART PER TEMPLATE DT9432

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CHECKED		
MFG. APPR.		
APPROVED		
DE APPR.		
DATE	09.10.08	

RELEASED
2009-10-13

W1053899



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